

109014

Work Order # 101282-2 **SPLIT-2**

101282

Item ID: D350-591-311
 Revision ID:
 Item Name: Heli-Access-Step, Long LH
 Start Date: 5/07/13 Start Qty: 10.00
 Required Date: 6/20/13 Req'd Qty: 10.00
 Reference:

Accept

N9000040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan: *MLJ*
 QC:

Date: *13-05-07* Tooling:
 Date: SPC (Y/N):

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100		0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								
110		0.00							
110	Large Fab								
Large Fab		0.00							
Large Fab	Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <i>126430</i> <i>123998</i> 3-Grind End Plate flush								

DAS
6
9-89

13/1/4

(3)

10

φ

13.09.18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 101282

101282

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step. Long L.H

Stop *NS2*

Start Date: 5/07/13 Start Qty: 10.00

10

Required Date: 6/20/13 Req'd Qty: 10.00

10

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

③ B-09-19

DAS
09
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

③ B-09-19

DAS
09
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

③ φ H6139-20
13-9-19

20/

Work Order 101 101282

101282

Item ID: D350-591-311

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step. Long LH

Start Date: 5/07/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/20/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

3

φ

DAS
19
9-89

13.10.30

180

Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod 123928

6-Grind End Plate flush

7-Install last rivet as per Dwg.

3

φ

LH
13.10.30

Work Order ID 101282

101282

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step. Long LH

Stop *NS2*

Start Date: 5/07/13 Start Qty: 10.00

10

Required Date: 6/20/13 Req'd Qty: 10.00

10

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

(3) 13-10-31

DAS
9
9-89

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

(3) 13-10-31

DAS
9
9-89

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HardFinish

Memo

0.00

Hand Finishing

3 13-10-30

85
8
100

85
8
100

Work Order ID 101282

101282 13-11-04 3x 26 11

101282

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 5/07/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/20/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

220

White Gloss(Ref 4.3-5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:35

OVEN TEMPERATURE: 320°

FINISH TIME: 9:05

3 0 13-11-1

DAS
34
9-89

230

Wing Walk as per dwg QSI005 4.4 Batch M1271 0.00

0.00

230

HandFinish

Memo

0.00

Hand Finishing

3 H H of 13-11-04

240

QC3- Inspect Part Finish

0.00

240

QC

Memo

0.00

Quality Control

3

13-11-04

240
43
600

Work Order ID 101282

101282

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, Long L11

Stop *NS2*

Start Date: 5/07/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/20/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

3

DAS
33
9-89

13-09-26

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

DAS
6
2-89

13/11/4

3

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: 14A

3 13/11/4

Work Order ID 101282

May 07-13 11:38:26 AM

101282

Item ID: D350-591-311

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 5/07/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/20/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 13-11-05

W134105

Work Order ID: 101282

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

101282

D350-591-311

Start Date: 5/07/13

Start Qty: 10.00

Required Date: 6/20/13

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified

by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3272-1

Manufactured No

110

Each

0.0000

1

10

D3272-1

Step

B103730 →

**

(x10)

13.08.28

D3067-1

Manufactured No

110

Each

161.0000

1

10

D3067-1

End Plate

**

13.09.12

Location

Loc Qty

Loc Code

WA

B102662

78

95515

5

98655

73

WA003

83

67582

2

68214

1

78608

4

79607

1

83855

1

90178

1

90486

3

95170

64

95930

6

10

Picklist Print

Work Order ID: 101282

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

101282

D350-591-311

Start Date: 5/07/13

Start Qty: 10.00

Required Date: 6/20/13

Required Qty: 10.00

D3219-1

Manufactured No

110

Each

92.0000

2

20

D3219-1

Plate

**

113-09-12

Location

Loc Qty

Loc Code

WA003

8101460

92

20

73410

12

77674

6

89967

2

96264

72

D3066-1

Manufactured No

180

Each

51.0000

2

20

D3066-1

Spacer

**

113-10-30

Location

Loc Qty

Loc Code

WA003

8107436

61

95963

4

99840

57

MS20600-AD4W4

Purchased No

180

Each

1,062.000

16

160

MS20600-AD4W4

Rivets

**

113-10-30

Location

Loc Qty

Loc Code

ST311

3125571

1062

48

123900

350

125406

712

D3065-041

Manufactured No

180

Each

17.0000

1

10

D3065-041

Step Leg Assembly Hi

**

113-10-30

Location

Loc Qty

Loc Code

WA003

8103486

17

3

79336

1

97928

16

Work Order ID: 101282

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

101282

D350-591-311

Start Date: 5/07/13

Required Date: 6/20/13

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180

Each

161.0000

1

10

D3067-1

End Plate

**

1513 10 30

Location

Loc Qty

Loc Code

WA

B101785

78

95515

5

98655

73

WA003

83

67582

2

68214

1

78608

4

79607

1

83855

1

90178

1

90486

3

95170

64

95930

6

3

AN3-35A

Purchased

No

250

Each

405.0000

2

20

AN3-35A

Bolt

**

6

DAS
33
9-89

13-09-20

Location

Loc Qty

Loc Code

FG

10

122800

10

ST352

395

125211

395

125211

JAS
6
9-89

DAS
31
9-89

Work Order ID: 101282

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

101282

D350-591-311

Start Date: 5/07/13

Required Date: 6/20/13

Start Qty: 10.00

Required Qty: 10.00

D3235-1

Manufactured No

250 Each 251.0000

2 20

D3235-1

Mounting Lug

** (64) 10 2818

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST470

251

90002

2

92286

1

96415

28

99256

100

99406

120

D3278-041

Manufactured No

250 Each 64.0000

1 10

D3278-041

Support Assembly

** (34) 10 3435

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST470

64

90706

1

97909

23

99297

40

AN960JD416

NAS1149D0463H Purchased

No

250 Each 0.0000

16 160

AN960.ID416

Washer

** (484) 12 6221

DAS
33
9-89

DAS
31
9-89

AN960JD516

NAS1149D0563J Purchased

No

250 Each 2.0000

4 40

AN960.ID516

Washer

** (44) 12 5807

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST504

2

1069059

2

Work Order ID: 101282

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

101282

D350-591-311

Start Date: 5/07/13

Required Date: 6/20/13

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

127.0000

2 20

AN5-36A

Bolt
DAS
6
9-89

** (6x) 126105

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST338

1

123525

1

ST517

126

125388

126

D2618

Manufactured

No

250

Each

244.0000

2 20

D2618

Bushing
DAS
6
9-89

** (6x) 105836

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST013

244

89275

1

97780

124

99529

119

D2230-3

Manufactured

No

250

Each

420.0000

4 40

D2230-3

Lug
DAS
6
9-89

** (12x) 102758

DAS
33
9-89

13-09-20

Location

Loc Qty

Loc Code

FG

4

89045

4

ST469

416

89782

19

90514

1

94957

4

96117

7

97815

373

97903

4

98912

8

DAS
31
9-89

Work Order ID: 101282

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long L.H

101282

D350-591-311

Start Date: 5/07/13

Required Date: 6/20/13

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 1

266.9839 1.2 12

D2856-400

Abrasion Strip

**

101773

DAS
33
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST408	153.45	
99378	153.45	
ST410	38.5	
95159	38.5	
ST415	75.0339	
63735	0.6696	
68076	0.3149	
71164	8.46	
81875	6.398	
86905	0.9569	
89352	24.6745	
90764	33.56	

99378 (1) 7.20

DAS
31
9-89

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

4,195.000

2 20

MS21042L3

Nut

**

6x 126275

DAS
33
9-89

13-09-20

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001	3	
122141	3	
GA	18	
122452	18	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	3906	
123900	974	
124291	2932	

DAS
31
9-89

Shop Packet Print

Work Order ID: 101282

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

101282

D350-591-311

Start Date: 5/07/13

Required Date: 6/20/13

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

863.0000

8

80

AN4-13A

Bolt

**

(242) 125709

DAS
33
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

Return2012

8

122416

8

ST513

812

125388

812

ST514

23

122993

13

123900

10

MS21042L5

Purchased

No

250

Each

149.0000

2

20

MS21042L5

Nut

**

(62) 125654

DAS
33
9-89

Location

Loc Qty

Loc Code

ST506

149

123900

149

MS21042L4

Purchased

No

250

Each

485.0000

8

80

MS21042L4

Nut

**

(242) 126275

DAS
33
9-89

Location

Loc Qty

Loc Code

FP001

50

122452

38

8182

12

ST518

435

124231

435

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40

AN960JD10

Washer

**

(122) 126319

DAS
33
9-89

May-07-13 11:38:29 AM

Shop Packet Print

Page 7

38

72

301

344

33



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

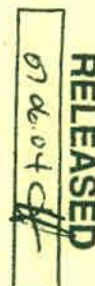
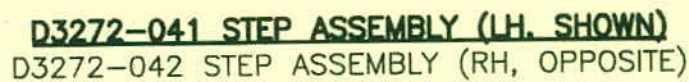
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

101282 MJS
130503

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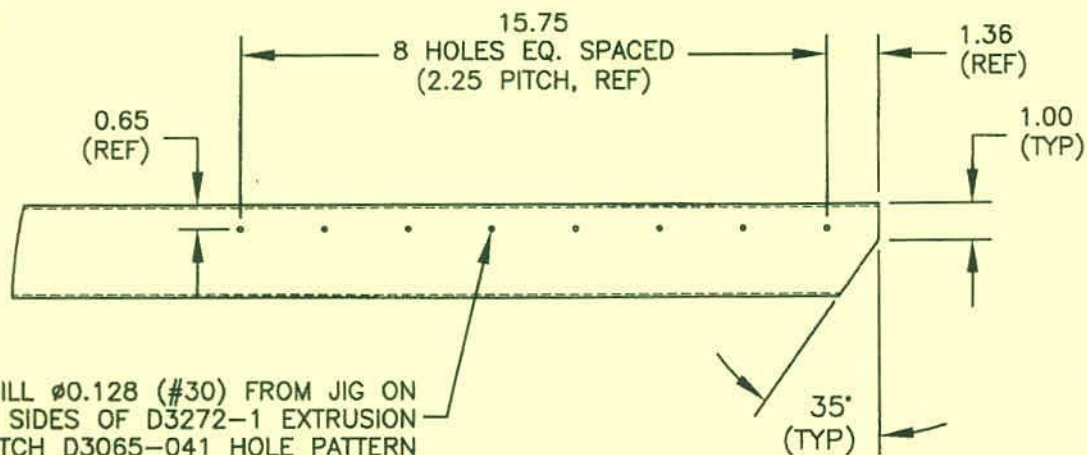
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DART

△ B D3272-1 STEP
 (MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
 BOTH SIDES OF D3272-1 EXTRUSION
 TO MATCH D3065-041 HOLE PATTERN

DETAIL C
 (SCALE 1:5)

RELEASED

07.06.04

DESIGN	90	DRAWN BY	JR	DART AEROSPACE LTD	REV. B
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA	
DATE	07.05.18	TITLE	D3272	SHEET 3 OF 3	SCALE
			STEP ASSEMBLY, HI LONG		1:20

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DATE RECEIVED

Devo-ka

LOT TRACKING !!

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date
AN8-35A	101282	-20	125211	9/20/13 2:55:57 PM
AN4-12A	101282	-80	m125709	9/20/13 2:55:59 PM
AN5-36A	101282	-20	M126105	9/20/13 2:55:58 PM
D2230-3	101282	-40	102768	9/20/13 2:56:58 PM
D2618	101282	-20	105836	9/20/13 2:55:58 PM
D2856-400	101282	-9	99378	9/20/13 2:55:59 PM
D2856-400	101282	-3	101773	9/20/13 2:55:59 PM
D3065-041	101282	-1	107073	9/23/13 8:54:51 AM
D3065-041	101282	-6	103486	9/26/13 9:07:16 AM
D3066-1	101282	-20	101818	9/23/13 8:54:51 AM
D3067-1	101282	-10	102662	9/26/13 9:08:55 AM
D3067-1	101282	-10	101785	9/23/13 8:54:51 AM
D3219-1	101282	-20	101460	9/23/13 8:54:51 AM
D3225-1	101282	-20	102818	9/20/13 2:55:57 PM
D3272-1	101282	-10	103730	9/23/13 8:54:51 AM
D3278-041	101282	-10	103435	9/20/13 2:55:57 PM
MS20600-AD4W4	101282	-112	125577	9/26/13 9:07:16 AM
MS21042L3	101282	-20	M126275	9/20/13 2:55:59 PM
MS21042L4	101282	-80	m126275	9/24/13 7:14:09 AM
MS21042L5	101282	-20	125654	9/20/13 2:55:59 PM
NAS1149D0363J	101282	-40	m126319	9/20/13 2:55:59 PM
NAS1149D0463J	101282	-160	M126221	9/20/13 2:55:58 PM
NAS1149D0563J	101282	-40	m125807	9/20/13 2:55:58 PM

-10 remove 10 107 436

